Rate: User: Friday, 24/10/2008 12:55:40 PM

Julie Dawson

#### **Process Sheet**

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 42937

**Estimate Number** P.O. Number

Prsht Rev.

This Issue

: 24/10/2008 : NC

First Issue : //

: 39082

: 10310

S.O. No.

Type : MACHINED PARTS Part Number

**Drawing Name** 

: D26175

: N/A

: D2

**Drawing Number** 

- D2617 REV D2

: BUSHING

**Project Number** 

**Drawing Revision** 

Material **Due Date** 

: 31/10/2008

Qty:

50 Um:

Each

Written By Checked & Approved By

Comment

**Previous Run** 

04.07.14

Reformat; added step 5 KJ/JLM

Additional Product

Job Number:



Seq. #:

1.0

**Machine Or Operation:** 

Description:

6061-T6 RD Tube .500 x.058W

M6061T6T0500W058

Comment: Qty.: 0.0205 f(s)/Unit Total: 1.0238 f(s)

6061-T6 Round Bar 1.5"

Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)

Ø0.500" tubing x 0.058" wall M6061T6T0.500W.058) Batch M 109/10

2.0

HARDINGE

HARDINGE CNC LATHE SMALL







Comment: HARDINGE CNC LATHE SMALL

1-Machine as per Folio FA438 and Dwg D2617

2-Deburr

3.0 QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0



5.0

SECOND CHECK



Comment: SECOND CHECK

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1



08/10/30



W/O:			W	ORK ORDER CHAN	GES						
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		40									
										i.	
		PAR #:	Fault Cat	egory:	NCR: Yes No DQA: Date:						
		solution:	Dispositi	on:	QA: N/C Closed:				Date:		
NCR:		,	WORK ORI	DER NON-CONFORM	MANCE	(NCR)					
DATE	STEP	Description of NC	Corrective Action Secti			Veriti			Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	Secti		Chief Eng	QC Inspector	

Friday, 24/10/2008 12:55:40 PM Date: Julie Dawson User: **Process Sheet** Drawing Name: BUSHING Customer: CU-DAR001 Dart Helicopters Services Job Number: 42937 Part Number: D26175 Job Number: Seq. #: Machine Or Operation: **Description:** INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 6.0 **Comment: INSPECT ALODINE** PACKAGING RESOURCE #1 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 08/11/03 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

W/O:			WO	RK ORDER CHA	NGES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date Q1	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
W-00										
Part No:PAR		PAR #:	Fault Categ	ory:	NCI	R: Yes N	es No DQA: Date:			
		esolution:	Disposition: C			N/C Clo	sed:	Date: _		
NCR:		V	VORK ORDE	R NON-CONFO	RMANCE	(NCR)				
DATE	STEP	Description of NC			Section B		Verification	n Approval	Approval	
DAIE	SIEP	Section A	Initial Chief Eng	Action Descript Chief Eng	cription Sign & Date		Section C	Chief Eng	QC Inspector	
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DART AEROSPACE LTD	Work Order: 42937
·	
Description: Bushing	Part Number: D2617-5
Inspection Dwg: D2617 Rev: D2	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

	X	First Arti	cle _	Prot	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.223	+0.000/-0.010	,2225	//			
0.500	+/-0.010	3225				
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Measured by:	45	Audited by:	J.L	Prototype Approval:	N/A
Date:	0126	Date:	08/10/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.08.09	New Issue	KJ/JLM	
В	06.03.08	Dwg Rev change	KJ/JLM 14	
C	08.01.16	Tolerance revised for 0.500 dimension	KJ/EC/DD	- X

W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		PAR #:								
	Res	colution:						Date: _		
NCR:			WORK ORD	ER NON-CONFORM		l) 		·	γ	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	Sign 8	Verific Secti		Approval Chief Eng	Approval QC Inspector	
			Office Eng	One: Eng						
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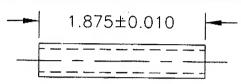


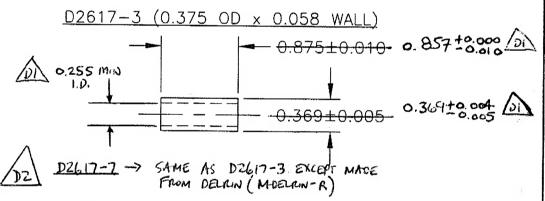
1	DESIG	BW	DRAWN BY	DART AEROS HAWKESBURY, ONT.	
•	CHEC	KED #	APPROVED	DRAWING NO. D2617	REV. D SHEET 1 OF 1
	DATE			TITLE	SCALE
	01.0	07.04		BUSHING	1:1
	Α		96 10 08	NEW ISSUE	

DZ 04.04.10 #CD ADD 02617-7

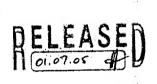
В 97.05.08 .875 WAS 1.125 Ċ 97.06.04 0.369 DIA WAS 0.375 01.07.04 ADD MAT'L SPEC AND TOL./DIM. NOTE 04.07.12 CORRECT TOLERANCE (NCR 779)

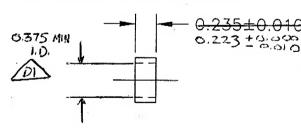
D2617 - 10.058 WALL





D2617-5 (0.500 OD x 0.058 WALL)





<del>235±0.010</del>-SHOP COPY **RETURN TO ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

NOTES:

1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)

OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)

BREAK ALL SHARP EDGES 0.005 TO 0.010

3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

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W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAN	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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			4							
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Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQ	<b>A:</b>	_ Date: _		
	R	esolution:	Disposition	:	_ QA: N/C C	A: N/C Closed: Date:				
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCF	3)		· · · · · · · · · · · · · · · · · · ·		
DATE	CTED	Description of NC	(	on B	Verific	ation	tion Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	Secti		Chief Eng	QC Inspector	
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